

Work Order ID 80620

Friday, February 24, 2012 1:29:51 PM

80620

SOON
Page 1

Item ID: D3955-041
Revision ID:
Item Name: Doubler Assembly

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Start Date: 2/24/2012 Start Qty: 5.00 *5*
Required Date: 2/27/2012 Req'd Qty: 5.00 *5*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MF
QC:

Date: 12-02-24 Tooling:
Date:
Date: SPC (Y/N):

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3955	A

100		0.00
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100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3955-1

Dwg Rev: 2

Prog Rev: 2

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC

Quality Control

Memo

0.00

W 12-02-26 (5)

W 12-02-26 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 2/27/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

2- Deburr if necessary

140

0.00

140

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

8/2/02/28

8/2/02/27

X5

Dart Aerospace Ltd

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Reference:

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Customer:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

5 2 8 28 12/02/28

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

5x8 m-l 12/02/28

170

Pick Kit

0.00

170

Packaging

Memo

0.00

Packaging

6/2/28 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

180

Small Fab

Memo

0.00

0.00

Small Fab

1- Assemble nut plate as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 076

0.00

200

Packaging

Memo

0.00

Packaging

Handwritten signature and date: 12/2/28 (5)

Handwritten initials: XS

Handwritten signature and date: 12/2/28 (5)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/2/28
MF
12-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Friday, February 24, 2012 1:29:50 PM

Page 1

Work Order ID: 80620
Parent Item: D3955-041
Parent Item Name: Doubler Assembly

Start Date: 2/24/2012

Required Date: 2/27/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	186.5096	0.3553	1.87			

W 12.02.22

Location	Loc Qty	Loc Code
MAT021	186.5095684	
113608	0	
116308	9.95556842	
117285	72.414	
119331	49.2	
119802	22.94	
120218	32	

MS21086L3 Nut Plate	Purchased	No	180	Each	21.0000	1	5
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Location	Loc Qty	Loc Code
ST303	21	
117519	21	

MS20427M3-3 Rivet	Purchased	No	180	Each	788.0000	2	10
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Location	Loc Qty	Loc Code
ST318	788	
118384	788	

117519

118384

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order: 80620
Description: Doubler		Part Number: D3955-1
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.129	✓		VERN	HB-02
Ø0.201	+0.005/-0.001	0.201	✓		VERN	" "
0.750	+/-0.010	0.748	✓		VERN	" "
1.000	+/-0.010	0.999	✓		VERN	" "
1.250	+/-0.010	1.252	✓		VERN	" "
1.375	+/-0.010	1.374	✓		VERN	" "
2.38	+/-0.030	2.38	✓		VERN	" "
0.613	+/-0.010	0.614	✓		VERN	" "
1.313	+/-0.010	1.313	✓		VERN	" "
2.063	+/-0.010	2.065	✓		VERN	" "
2.563	+/-0.010	2.566	✓		VERN	" "
3.063	+/-0.010	3.063	✓		VERN	" "
4.813	+/-0.010	4.810	✓		VERN	" "
6.313	+/-0.010	6.313	✓		MT	M.M.02
7.313	+/-0.010	7.313	✓		MT	" "
7.813	+/-0.010	7.813	✓		MT	" "
8.199	+/-0.010	8.199	✓		MT	" "
8.449	+/-0.010	8.449	✓		MT	" "
9.188	+/-0.010	9.188	✓		MT	" "
9.438	+/-0.010	9.438	✓		MT	" "
10.413	+/-0.010	10.413	✓		MT	" "
10.75	+/-0.030	10.78	✓		MT	" "
0.063	+/-0.010	0.063	✓		VERN	HB-02

Measured by:	unw
Date:	12.02.26

Audited by:	S
Date:	12/02/27

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	P/O D3955-041	KJ

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

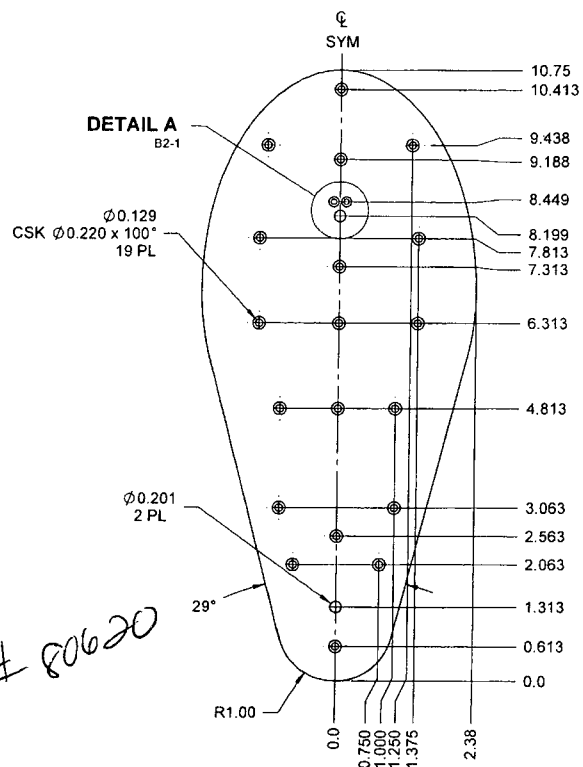
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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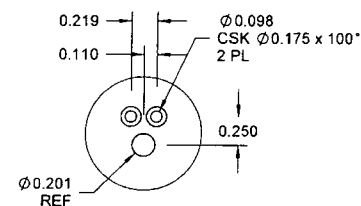
NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



0.063
REF

INSTALL
MS21086L3 NUT PLATE
MS20427M3-3 RIVET, 2 PL



DETAIL A D7-1
SCALE 2X

D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/22 AMP

D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. PART SPEC. M6061 T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

A	NEW ISSUE	RF	09.07.21
REV.		DESCRIPTION	BY DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3955 TITLE SKIDTUBE TUNING KIT	REV. A
DRAWN	RF		SHEET 1 OF 5
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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